



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

648.4709

Job Sheet 172730



Part No: 648.4709

Job Qty: 1 ea

Part Name: SWA10A Overhaul



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/21/18

Job Tracking No:

Due Date: 4/27/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG OM_OOPM-SWA10A Rev 3 (648.4709) IPP Rev A 18.01.25 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea		4/27/18	0.00	0.00	Start Up Small Fab-4		MCL
110	Small Fab	1 pcs		4/27/18	0.00	0.00	Small Fab-4		MCL DAS
120	QC	1 pcs		4/27/18	0.00	0.00	QC5		38
121	DC	1 pcs		4/27/18	0.00	0.00	DC		9-88
130	Packaging	1 pcs		4/27/18	0.00	0.00	Packaging3-1		APR 24 2018
140	QC21-FG	1 Ea		4/27/18	0.00	0.00	QC21		

Part Op 110 - Pick bag and tag.

Descriptions: 121 - Supply owner's & overhaul procedures manual

DAS
21
9-88

APR 24 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
188-FPSS-1032-1/2	Set Screw	1 Ea (1 ea)	90-Start up Operation	SO 37670
188-FPSS-1032-3/8	Set Screw	1 Ea (1 ea)	90-Start up Operation	SO 37669
188-FPSS-1032-5/8	Set Screw	1 Ea (1 ea)	90-Start up Operation	SO 37083
188-FSCS-1032-5/8	Wire Clamp Screw	4 Ea (4 ea)	90-Start up Operation	SO 31242
600.1319	Up Decal	1 Ea (1 ea)	90-Start up Operation	SO 36704
EL314-SJTOW	3 Wire	6 ft (6 ea)	90-Start up Operation	SO 29542
SWA10A-1100	Upper DU Bearing	1 Ea (1 ea)	90-Start up Operation	SO 60819
SWA10A-1200	Lower DU Bearing	1 Ea (1 ea)	90-Start up Operation	SO 36190
SWA10A-1300	Roller Thrust Bearing	1 Ea (1 ea)	90-Start up Operation	SO 36127
SWA10A-1400	Circlip	1 Ea (1 ea)	90-Start up Operation	SO 38191
SWA10A-400	Thrust Washer	1 Ea (1 ea)	90-Start up Operation	SO 49920
SWA6A-1900	Female Spade Terminal - 1/4"	12 Ea (12 ea)	90-Start up Operation	SO 27243
SWA6A-2000	1/8" Female Spade Connector	4 Ea (4 ea)	90-Start up Operation	SO 29410

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	188-FPSS-1032-1/2	1	100	0
	188-FPSS-1032-3/8	1	100	0
	188-FPSS-1032-5/8	1	199	0
	188-FSCS-1032-5/8	4	184	0
	600.1319	1	250	0
	EL314-SJTOW	6	247	0
	SWA10A-1100	1	6	0

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid- _____ Mach _____ Thermoform _____ Large _____
Date : _____	Step #: _____	QTY _____
Description Work Order Deviation		ering ☐ ality ☐)ther ☐ 2) Approval ☐ ted By _____ Supervisor _____ rification _____ rdinator _____ val _____ Wrong _____ nensions _____ r tolerance _____ ct _____ issing _____
Root Cause		
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐
Temperature/C _____ Set-up _____ BOM/Route _____ Broken/Damaged _____ Inspection Inco _____ Contamination _____ Countersink _____ Cut Too Short _____ Instructions Inco _____ Drill Holes _____		
OTHER : _____		

Date: 04/19/18
 Inspector: _____
 Revision: 3
 Serial No/Batch: S062640
 Job No: 172730
 Part: 648.4709
 Container No: S062640
 AEROSPACE
DART
 1270 Aberdeen Street
 Hawkesbury, ON K6A 1K7
 CANADA
 TEL: 1 613 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

SWA10A-1200	1	10	0
SWA10A-1300	1	10	0
SWA10A-1400	1	10	0
SWA10A-400	1	0	0
SWA6A-1900	12	88	0
SWA6A-2000	4	100	0

Part Specifications

Specifications could not be found.

Plex 2/21/18 2:17 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval				
Description Work Order Deviation				Disposition							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter		FAULT CATEGORY		☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes		☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center		☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence	
		☐ OTHER : _____									

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 PRIOR WRITTEN PERMISSION OF LINT ENGINEERING, CHN.

The drawing consists of three main views: a top view, a cross-section, and a detail view. The top view shows a central rectangular block with two cylindrical features on either side, each with a horizontal slot. A dashed line indicates the center of gravity, and an arrow labeled 'UP' points upwards. The cross-section, labeled 'SECTION A-A', shows the internal components of the assembly, including a central shaft and various housing parts. It is labeled 'UPPER END SWIVEL' at the top and 'LOWER END' at the bottom. A circular detail view on the right shows a close-up of the internal components, with labels 'SWA10A-500' and 'SWA10A-600' pointing to specific parts. The drawing is titled 'DETAIL B' and 'SCALE 2 : 3'.

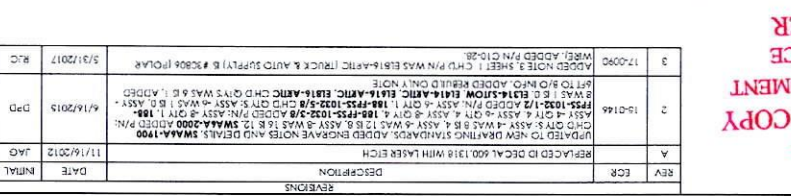
DETAIL B
 SCALE 2 : 3

SECTION A-A
 UPPER END SWIVEL
 LOWER END

SWA10A-500
 SWA10A-600

UP

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER



DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

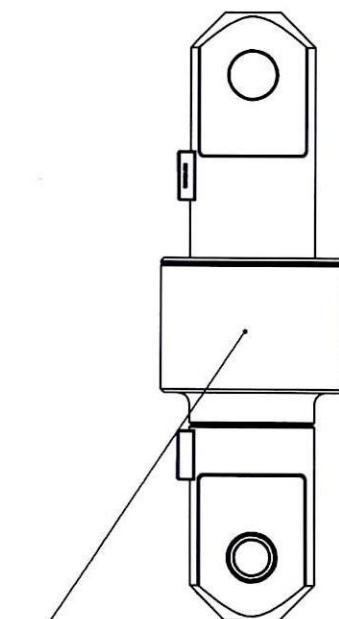
Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐							
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval				
Description Work Order Deviation				Disposition				Completed By			
								Lead hand / Supervisor Approval Verification			
								QC / QA Coordinator Approval			
Root Cause		FAULT CATEGORY									
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER :							
Misidentified	☐	Past Due	☐								

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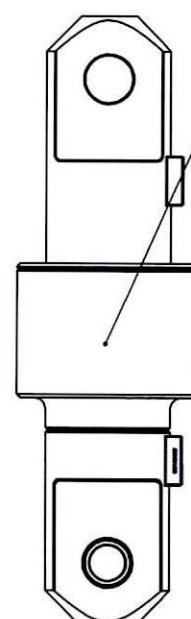
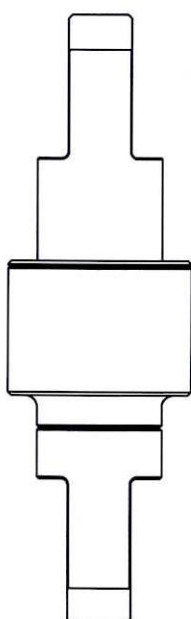
REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED



ENGRAVE P/N, S/N, SWL



LASER ENGRAVE DART LOGO



DART AEROSPACE	
TITLE SWA10A SWIVEL	
DWG NO. SWA10A	
REV 3	
MAT'L	UNLESS OTHERWISE SPECIFIED
HEAT	DIMENSIONS ARE IN INCHES
TREAT	.XXX ± .005 FRACTIONS ± 1/8
FINISH	.XX ± .01 ANGLES ± 5°
SPEC	.X ± .1 SURFACES = 125/√
DRAWN BY: GILBERT	1. BREAK ALL SHARP EDGES
CHECKED: DD 04/18/2017	.015 x 45° OR .015R
OPPS APPR: AA 05/05/2017	2. DIMENSIONAL LIMITS APPLY
QA APPR: JL 05/10/2017	AFTER PLATING
APPROVED: JAG 06/02/2017	3. INTERPRET DIM AND TOL PER
	ASME Y14.5M-2009
	USED ON MODEL
SCALE 1:4	DATE 11/14/2012
	SHEET 2 OF 2

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
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				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
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Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
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Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
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Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
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